

# Work Order ID 70681

Monday, June 13, 2011 1:10:21 PM



Page 1

Item ID: D3836-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 6/13/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

*[Signature]*

Date: 6-06-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3836

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-1 and D3836-3 rib-as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

SAO 11-06-23

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: 117884

6- grind weld flush where indicated on dwg

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11.07.06

2

0

BE

11/07/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70681**

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Page 2

Item ID: D3836-041

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Setup Start



Revision ID:

Stop



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Start Date: 6/13/2011 Start Qty: 2.00



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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

~~PC~~

Memo

0.00

~~PC 11-07-06~~

2

0

Sub 7/6 (2) all

150



Packaging

Packaging

Identify as per dwg &amp; Stock Location: B/C

0.00

Memo

0.00

PC 11-07-06

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/7/6 J

MF 11-07-06

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 13, 2011 1:10:26 PM

Page 1

Work Order ID: 70681

Parent Item: D3836-041

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 6/13/2011


Required Date: 6/17/2011

Start Qty: 2.00

Required Qty: 2.00


Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3		Manufactured	No			100	Each	2.0000	1	2			
													
Spacer Bushing													

Location	Loc Qty	Loc Code
----------	---------	----------

WA	2	
69436	2	

M304TS0.750W.065		Purchased	No			100	f	939.2120	1.7808	3.749053			
													
304 SQ Tube .75x.75x.065W													

Location	Loc Qty	Loc Code
----------	---------	----------

MAT018	825.357	
117598	747.6583	
117636	77.6987	
WA007	113.8549906	
116267	99.549272	
116763	14.3057186	

PC 11.07.05

B70724 → (5)

SAD 11-06-23

3.7491

**Dart Aerospace Ltd**

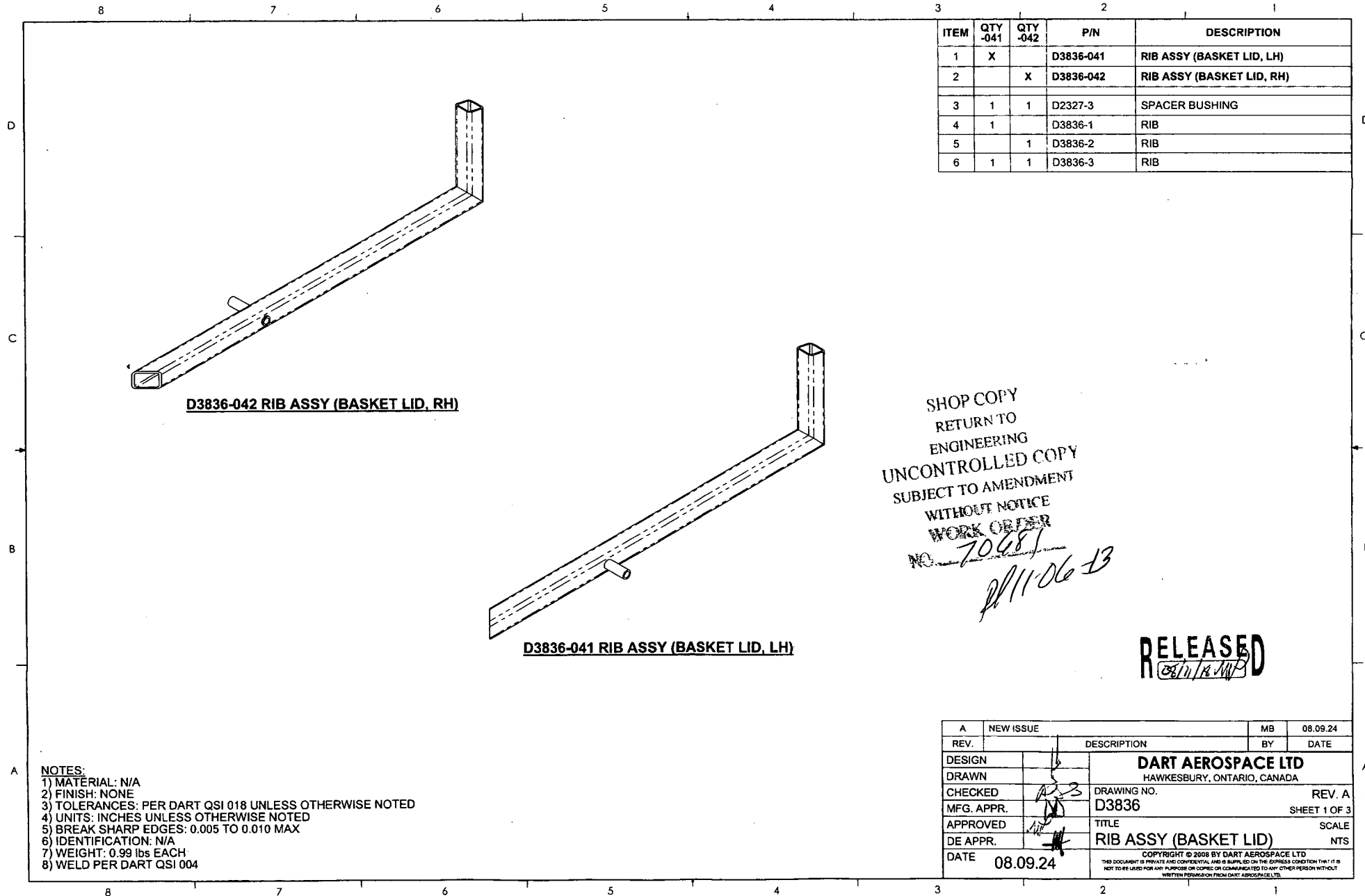
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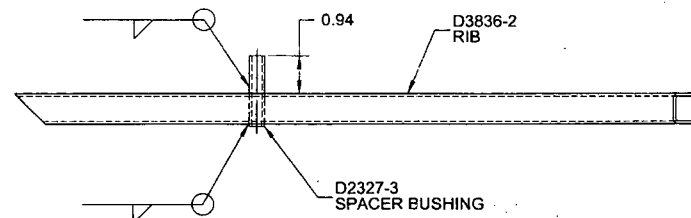
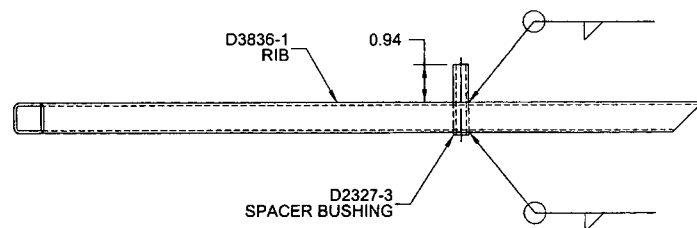
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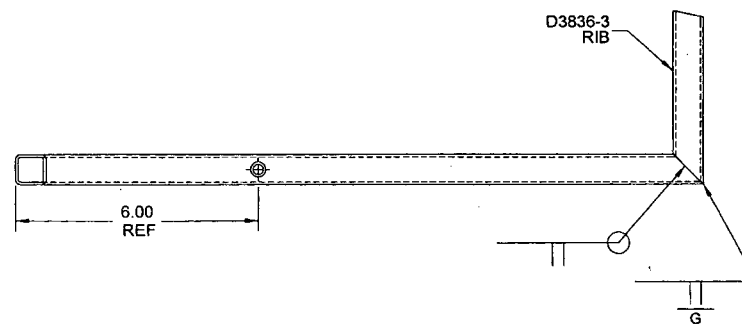
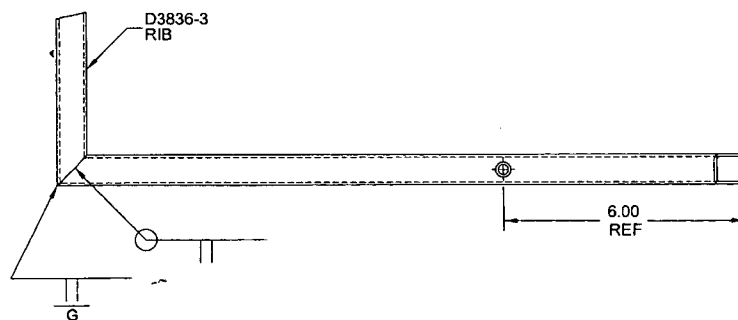
D

D



C

C



B

B

**D3836-041 RIB ASSY (BASKET LID, LH)**

**D3836-042 RIB ASSY (BASKET LID, RH)**

cto 70681

**RELEASED**  
08/11/18 MTR

A

A

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3836</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>RIB ASSY (BASKET LID)</b>	NTS
DATE	08.09.24	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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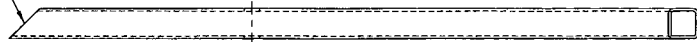
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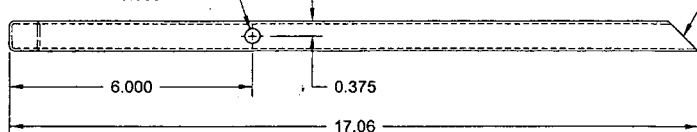
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0.75 X 45°  
CHAMFER

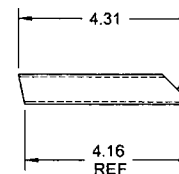


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0.75 X 45°  
CHAMFER

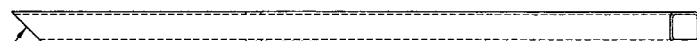
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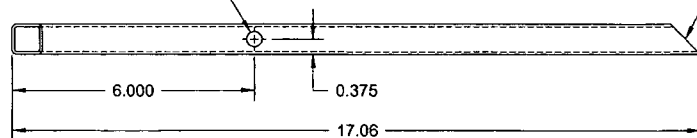
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CHAMFER

**D3836-3 RIB**

0.75 X 45°  
CHAMFER

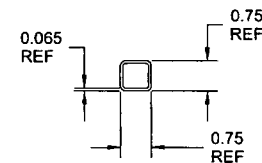


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0.75 X 45°  
CHAMFER

**D3836-2 RIB**



**TYPICAL SECTION  
VIEW**

**RELEASED**  
08/11/81

*w/o 70681*

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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